

ST525

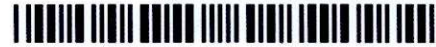


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Gloss Black

D3910-1
Job Sheet 203479



Part No: D3910-1

Job Qty: 2 pcs

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/19

Job Tracking No: Gloss Black

Due Date: 12/6/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D3910 REV.E IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Rework - 1 - Startup	2 pcs	12/6/19	12/6/19	0.00	0.20	Powdercoat - 1		
							Powdercoat - 2		BEB 19-11-29
							Powdercoat - 3		
							Powdercoat - 4		DR 19-12-6
150	Rework - 2 - B4B	2 pcs	12/6/19	12/6/19	0.00	0.00	QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		663 DEC 10 2019
							QC 3 - 19		
							QC 3 - 43		
							QC 3 - 24		
							QC 3 - 61		
							QC 3 - 81		
180	Packaging 3-1 - Stock - B4B	2 pcs	12/6/19	12/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

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DAS
81
9-89

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	58 DEC 12 2019
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	2 pcs	12/6/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89 DEC 12 2019
Part Op 140 - Scuff and re powder coat Powder coat white gloss as per QSI005 4.3.5 START TIME: _____ OVEN Descriptions: TEMPERATURE: _____ FINISH TIME: _____ 150 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
M.U. 013209					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D3910-1	Crosstube Lug	2 pcs (1 ea)	140-Rework - 1 - Startup	5199748.	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
140-Rework - 1 - Startup	D3910-1	2	78	0	

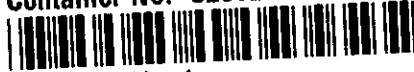
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
3	Crosstube Lug	0.270Inches $\pm$ 0.030	0.300 0.240	reference	
4	Crosstube Lug	0.310Inches $\pm$ 0.030	0.340 0.280		
5	Crosstube Lug	0.735Inches $\pm$ 0.010	0.745 0.725	reference	
6	Crosstube Lug	2.200Inches $\pm$ 0.030	2.230 2.170		
7	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
8	Crosstube Lug	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
9	Crosstube Lug	0.380Inches $\pm$ 0.030	0.410 0.350	Radius	
10	Crosstube Lug	0.380Inches $\pm$ 0.030	0.410 0.350		
11	Crosstube Lug	0.625Inches $\pm$ 0.010	0.635 0.615		
12	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
13	Crosstube Lug	3.700Inches $\pm$ 0.010	3.710 3.690		
14	Crosstube Lug	0.625Inches $\pm$ 0.010	0.635 0.615		
15	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
16	Crosstube Lug	0.340Inches $\pm$ 0.030	0.370 0.310	Radius	

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Container No: S236217



Part: D3910-1

Job No: 203479

Serial No/Batch: S236217

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/19